

shp Jan 16

Work Order ID 78084

78084

December-28-11 3:28:49 PM

Item ID: D3958-1KGY

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Panel

Start Date: 28/12/2011 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 16/01/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: M.C.J Date: 11/12/28

Tooling:

Date:

Run Start *NR1*

QC: Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3958	A
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100

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

I-Cut Sheet to required Blank size

x1 OK
12/01/12

105

0.00

105

HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp: 150°F

Time IN: 7:00 pm 12/01/11

Time OUT: 5:00 am 12/01/12

x1 OK
12/01/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

0.00

Thermoform

Thermoforming Machine

Memo

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA050 using tool DT9318
Dwg Rev: A
Folio Rev: C

120

QC2- Inspect parts off machine FAI/FAIB	0.00
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120

0.00

QC

Quality Control

Memo

Visually inspect part for proper formation and texture

130

QC8- Inspect parts - second check	0.00
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130

0.00

QC

Quality Control

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/1/12af

12/1/16 JF

MF
12-01-16

W/O:		WORK ORDER CHANGES					
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Picklist Print

December-28-11 3:28:53 PM

Page 1

Work Order ID: 78084

78084

Parent Item: D3958-1KGY

D3958-1KGY

Parent Item Name: Panel

Start Date: 28/12/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/021 DL

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-52068		Purchased		No		100	sf	1,011.893	2.4791	2.4791			

MKYD6185S 080-P3-52068

Kydex steel grey

Location

therm

111807

119476

Loc Qty

1011.893107

10.4896282

1001.40348

Loc Code

2.4791 sq ft.

12/01/13

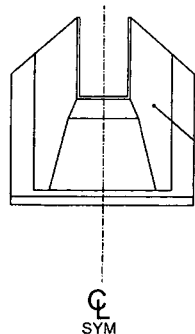
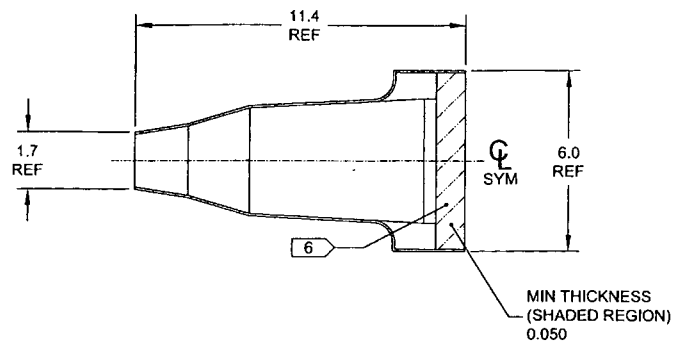
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D3958-1 PANEL

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 0.3 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9313 PER DART QSI 022. TRIM PER MOLD.
- 9) MINIMUM THICKNESS: 0.025" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3958-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3958-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

SH
P
EN
UNCONTROL
SUBJECT TO
WILL
WON

NO-78084 M.L.J
11/12/28

RELEASED
09/10/15/11/12

REV.	DESCRIPTION	PH	DATE
A	NEW ISSUE	PH	09.06.16
DESIGN		BY	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. A
D3958 SHEET 1 OF 1
TITLE SCALE
PANEL (206 L3/L4) NTS

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DART AEROSPACE LTD	Work Order: 78084
Description:	Part Number: D3958-LK64
Inspection Dwg: D3958 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1/8</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>OK</u>	Date: <u>12/01/12</u>
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
11.4 "	Ref	11.25'	✓		TAPE DL-01	
1.7 "	Ref	2.5 "	✓		TAPE DL-01	
6.0 "	Ref	6.0 "	✓		TAPE DL-01	
5.5 "	Ref	6.0 "	✓		TAPE DL-01	
1.0 "	± 0.100	1.0 "	✓		TAPE DL-01	
0.025 "	M.I.N.	0.028 "	✓		UEN DL-02	

Measured by: <u>OK</u>	Date: <u>12/01/13</u>
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Audited by: <u>5</u>	Date: <u>12/01/13</u>
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Preliminary Approval:	Date:
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Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14